

Work Order ID 72028

Monday, July 18, 2011 9:57:08 AM



Page 1

Item ID: D3443-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Weldment Assembly

Start Date: 7/18/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3443

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3443

EL 11-8-16 (X4)

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

Pln-08-17

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S wlos 11/7

(X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 72028

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Page 2

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Start Date: 7/18/2011 Start Qty: 3.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

0.00

1-Mask holes as per dwg D3443

START TIME: 9:30

OVEN TEMPERATURE: 400 OF

FINISH TIME: 10:00

4X Ø M/L 11/08/14

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

4 Ø M/L 11/08/14

150

Small Fab

0.00



Small Fab

Small Fab

Memo

0.00

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

ES 11/08/22 (4)

Dart Aerospace Ltd

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Work Order ID 72028




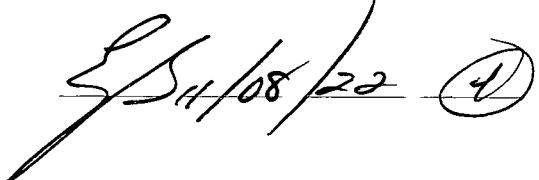

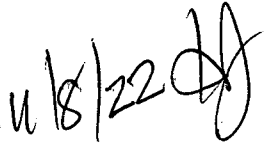

Monday, July 18, 2011 9:57:09 AM



Page 3

Item ID: D3443-041 Accept  Setup Start 
Revision ID:
Item Name: Strut Weldment Assembly Stop 
Start Date: 7/18/2011 Start Qty: 3.00  Cust Item ID:
Required Date: 7/25/2011 Req'd Qty: 3.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							 (X4)
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>G-A</u> Memo <u>w/o 71987 (2X)</u> <u>w/o 71989 (2X)</u>	0.00 0.00							 7/14/08/22 (4)
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 u/8/22 (4)  u/08-22 (4)

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NOTE: Date & initial all entries

Picklist Print

Monday, July 18, 2011 9:57:15 AM

Page 1

Work Order ID: 72028

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly









Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3443-1  Lug		Manufactured	No			100	Each	4.0000	1	3			
													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
WA 4													
70596 4													
D3443-5  Tubing		Manufactured	No			100	Each	3.0000	1	3			
													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
WA022 3													
69761 3													
D3453-1  Clevis		Manufactured	No			100	Each	4.0000	1	3			
													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST058 4													
71203 4													
D3965-4  Bearing, Spherical		Manufactured	No			100	Each	12.0000	1	3			
													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST100 12													
71181 12													

EL 10-8-16

4

EL 11-8-16

3

EL 11-8-16

4

EL 11/08/22

4

72036X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 18, 2011 9:57:15 AM

Page 2

Work Order ID: 72028



Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 3.00

Required Qty: 3.00

D3966-4-750

Manufactured No

100

Each

32.0000

2

6



EL 11-8-16

Pin, Dowel

Location

Loc Qty

Loc Code

ST100

32

58711

32

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

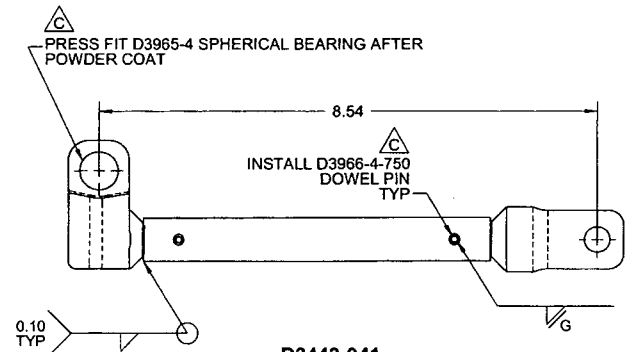
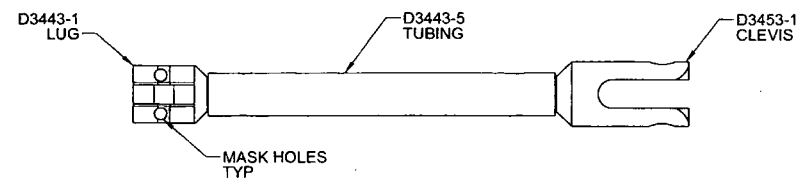
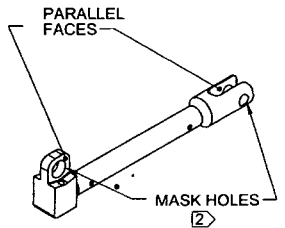
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



D3443-041

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72028

PA 1107-18

RELEASED
07/08/25 MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.33 lbs
 - 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.060 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3443	REV. C
MFG. APPR.	RF	SHEET 1 OF 4	
APPROVED	RF	TITLE STRUT WELDMENT ASSEMBLY NTS	SCALE
DE APPR.	RF	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.25		

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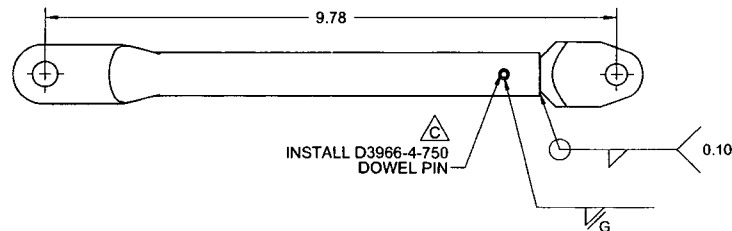
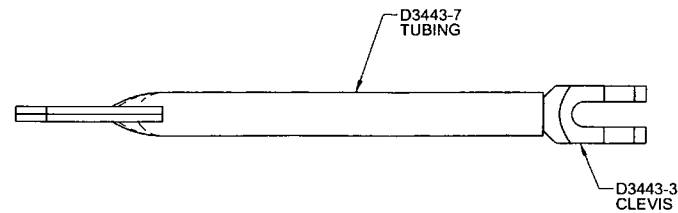
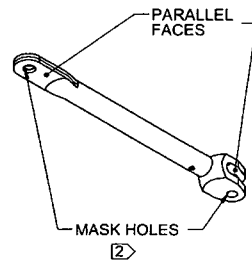
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
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09/06/25/14

72025

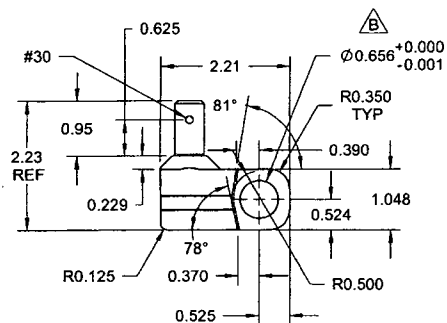
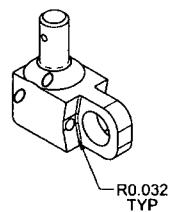
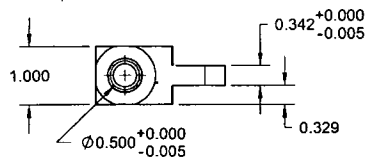
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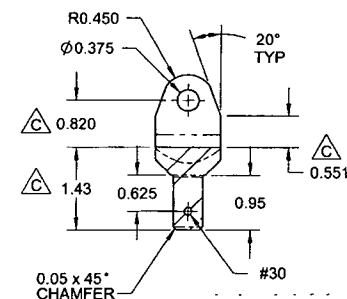
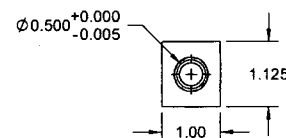
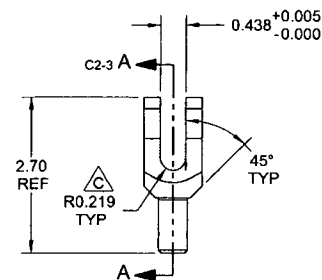
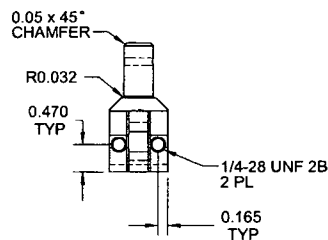
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D3443-1 LUG



SECTION A-A C4-3

D3443-3 CLEVIS

72028

RELEASED
09/08/25/14

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
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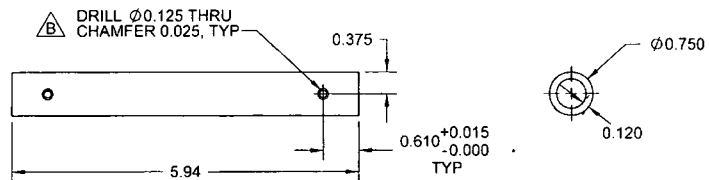
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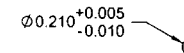
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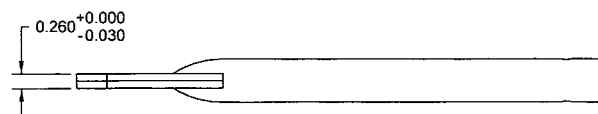
D3443-5 TUBING



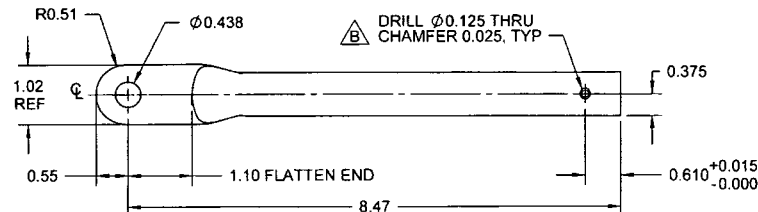
D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING



D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. C
MFG. APPR.	DP	D3443	SHEET 4 OF 4
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	STRUT WELDMENT ASSEMBLY NTS	
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01/28/25 MD

72028

Dart Aerospace Ltd

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